Dart Aerospace Ltd.

Date: Friday, 26/01/2007 1:59:10 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 30484
Estimate Number : 10831
P.O. Number : N/A
This Issue : 26/01/2007 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : MACHINED PARTS
Previous Run : 30280
Written By :
Checked & Approved By :
Comment : Est: B 00.06.26 New DWG rev, (mpp 2069) EC

Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Part Number : D29321
Drawing Number : D2932 UNDER REVIEW OK
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 12/02/2007 **Qty:** 4 **Um:** Each

07.01.26

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	7075-T7351 2X6.25X7.875

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
7075-T7351 2X6.25X7.875
Issue material from stock:
7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length
Batch No: B25349 SA 07.02.01 (5)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
5-Deburr & TUMBLE SA 07.02.02 (5)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet MB 07/02/03 (4)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET SA 07.02.02 (5)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
07.01.26	2	TOOL RAD FOR FLANGE POCKETS SHOULD BE R0.188				CP 07.01.26 DW QS 07.02	

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** ND **Date:** 07/02/13

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Friday, 26/01/2007 1:59:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 30484
Part Number: D29321

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	07/02/05 (4)
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	07/02/05 (4)
7.0	POWDER COATING	POWDER COATING M/103141 ATTN: paint 1pc grey 3x
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	07/02/09 x4
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	07/02/12 (4)
9.0	PACKAGING 1	PACKAGING RESOURCE #1 3 WHITE 1 GREY
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_______ 5+479	07/02/12 (4)
10.0	QC21	FINAL INSPECTION/W/O RELEASE (4)
	Comment: FINAL INSPECTION/W/O RELEASE	07/02/13

Job Completion

U 07/02/12

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30484
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.100	0.140		.121	.121	.121	.121		
B	0.100	0.140		.121	.122	.121	.122		
C	0.100	0.140		.120	.124	.122	.124		
D	0.210	0.230		.221	.219	.220	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505	~~DT8683~~	2.500	2.500	2.500	2.500		
K	0.257	0.262	~~DT8683~~	.258	.258	.258	.258		
L	0.312	0.317	~~DT8686~~	.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.119	.119	.120		
O	0.540	0.560		.548	.548	.548	.548		
P	0.490	0.510		.500	.494	.495	.494		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.249	.250	.249	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	~~DT8690~~	.320	.320	.320	.320		
X	1.125	1.145		1.134	1.1335	1.135	1.135		
Y	1.565	1.585		1.5735	1.5735	1.573	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	07.02.01

Audited by	
Date:	07/02/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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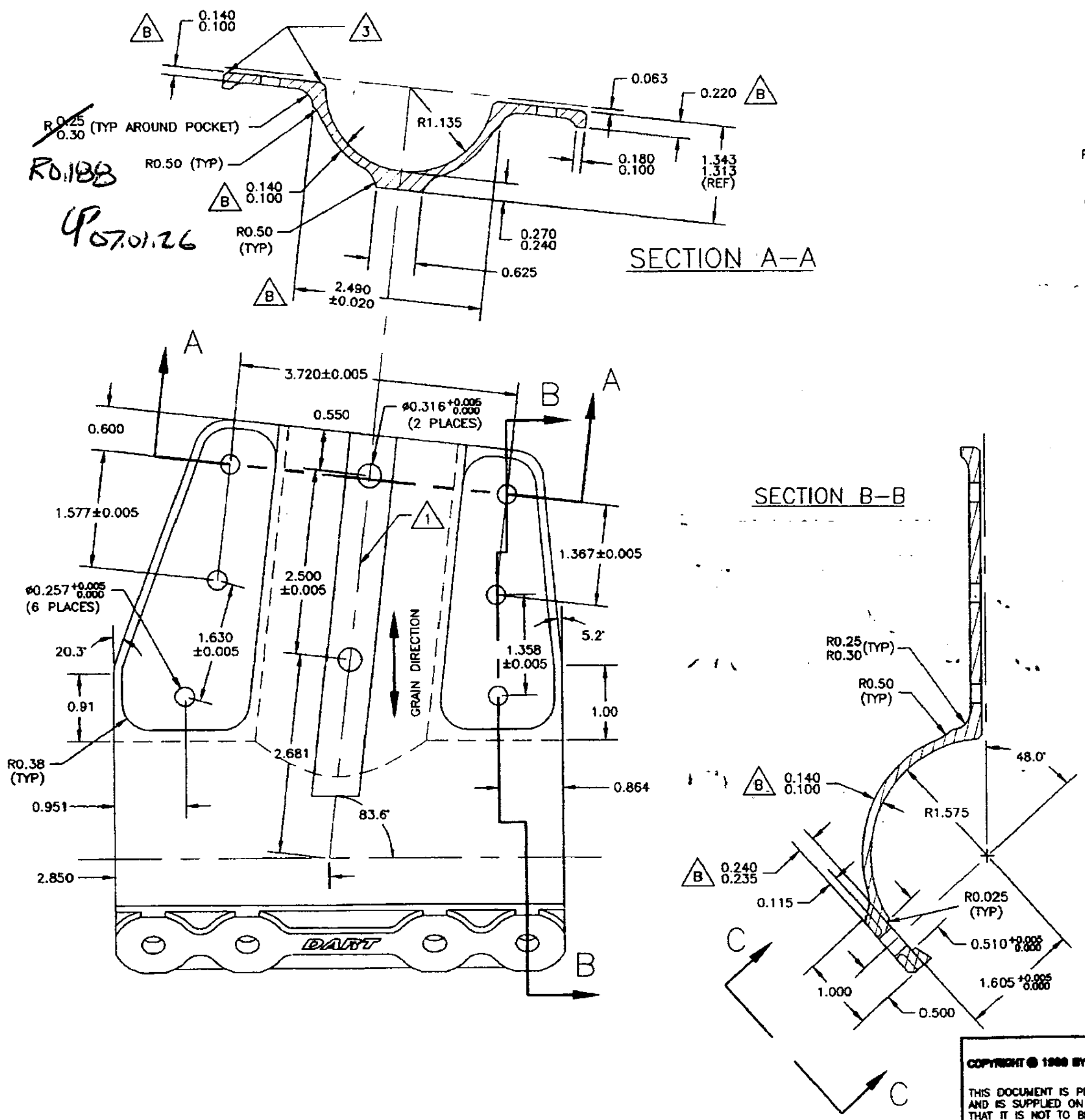

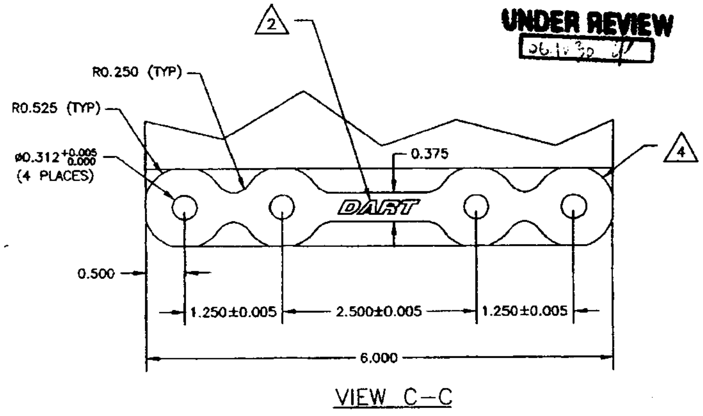

UNDER REVIEW

D2932–1 LH SADDLE (SHOWN)
D2932–2 RH SADDLE (OPPOSITE)

MATERIAL: 7075–T7351 (QQ–A–250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
2. ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
3. CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4. CHAMFER 0.050" x 45°

RELEASED 00.05.31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

DESIGN	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2932 — REV. B — SHEET 1 OF 1
DATE 00.05.29		TITLE SADDLE OUTSIDE — SCALE 2:3

P 07.01.26

C2011084
2011084 w/o

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle
Importance: High

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge